User

Tuesday, 11/29/2005 2:51:25 PM

Linda Lacelle

#### **Process Sheet**

Sp lib

: CU-DAR001 Dart Helicopters Services Customer Job Number : 25010

: NIA P.O. Number This Issue : 11/29/2005

**Estimate Number** 

: NC Prsht Rev.

: M/A :NIA

: 10512

S.O. No. : NIA

: MACHINED PARTS Type

**Drawing Name** 

Part Number **Drawing Number** 

: D26511 : D2651 REV. B

: PLUG

: N/A Project Number **Drawing Revision** : B ·NIA Material

: 11/29/2005

Qty:

400 Um: Each

Written By Checked & Approved By

First Issue

**Previous Run** 

: EST. KEUB OS ORTE 12 PE & Due Date : SEK ABOVE DATE IT USER

Comment : Created By Auto Work Order\*!!\* Late - Some of the material cannot

be made in time.

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6R0500

6061-T6 Round Bar .500"



Comment: Qty.:

0.0875 f(s)/Unit Total: 34.9860 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia M / 52/1 - 9

(M6061T6R0500)

Batch: M/6991 - 24.25

gal odialio 400

Tools:

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut Bar: 0.62" Long

Tools:

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA219 and Dwg D2651

2- Deburr

Identify as D2651-1

and ostialis 400

380

Tools:

4.0 A

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

And 05/12/10 400

Tools:

G

h

5,0

Small Sab.

Deberr as per Das 02651

Page 1

Dart Aer	ospace	Ltd		4							
W/O:			W	ORK ORDER CH	ANGES						
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
1 C											
1-1											
Part No:		PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	Date:	1	
						QA: N	/C Close	d:	_ Date: _		
NCR:		V	VORK ORI	DER NON-CONFO	RMANCE	(NCF	2)				
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector	
1 2										141 - 3	
100											

NOTE: Date & initial all entries

Tuesday, 11/29/2005 2:51:25 PM Date: User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: PLUG** Job Number: 25010 Part Number: D26511 Job Number: Seq. #: Machine Or Operation: Description: 師 QC8 SECOND CHECK 4.0 B Comment: SECOND CHECK Tools: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 SAO 05/12/20 Acid etch and Alodine as per QSI 005 4.1 Tools: POWDER COATING POWDER COATING 7.0 Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3 C6 02 20 (Only larger section necessary) Tools: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT 27 Tools: PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Tools: 10.0 DOCUMENT CONTROL Comment: DOCUMENT CONTROL 06-02-23 Inspection Level 21 Tools: Job Completion 4

# Dart Aerospace Ltd

W/O:			WORK	ORDER CHANGES	71%				
DATE	STEP	PRO	OCEDURE CHANGE	- The	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							4		
			- Hat	e we.					
				141					
Part No:	f	PAR #:	Fault Category: _	No	CR: Yes	No DQA	٨:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_

DATE STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
E							
		I I I I I					
				- 45			
1-1-1		185					30

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	0.058				
0.375	+/-0.010	0.374				
0.050 x 20°	+/-0.010	0.050x20°	_			
Ø0.305	+0.000/-0.002	80.304				
Ø0.438	+/-0.005	80.436	_			
0.060	+/-0.005	0.061				
0.090	+0.000/-0.002	0.089				
0.045	+0.000/-0.002	0.044	1			

Measured by:	m/	Audited by:	MS	Prototype Approval:	N/A
Date:	65/12/10	Date:	oslizlio	Date:	N/A.

Rev	Date	Change	Revised by	Approved
Α	03.12.22	New Issue	KJ/RF	

Dart Ae	rospace	Ltd					
W/O:		WORK ORDER	CHANGES				J.
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
							1-4 (
			354				(d <sup>a</sup> )
Part No	: <u></u>	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
			QA:	N/C Close	d:	_ Date: _	
NCR:		WORK ORDER NON-CON	FORMANCE (NC	R)			

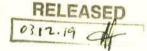
N	ICR:		WORK ORDER NON-CONFORMANCE (NCR)						
	110		Description of NC		Corrective Action Section B		Verification	Ammanual	
	DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						Who di			

NOTE: Date & initial all entries

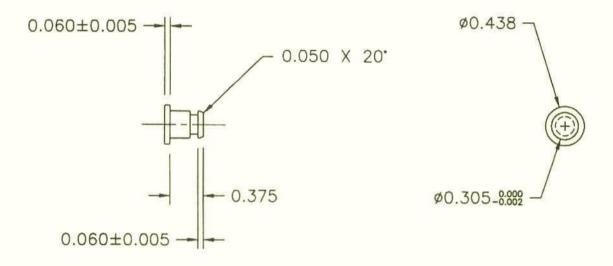




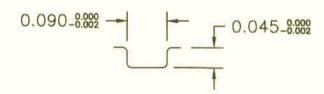
DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.1	9	PLUG	1:1
A	97.03.25	NEW ISSUE	
В	03.12.19	ADD POWDER COAT,	MS28775-008



#### D2651-1 PLUG:



# GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

# D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

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